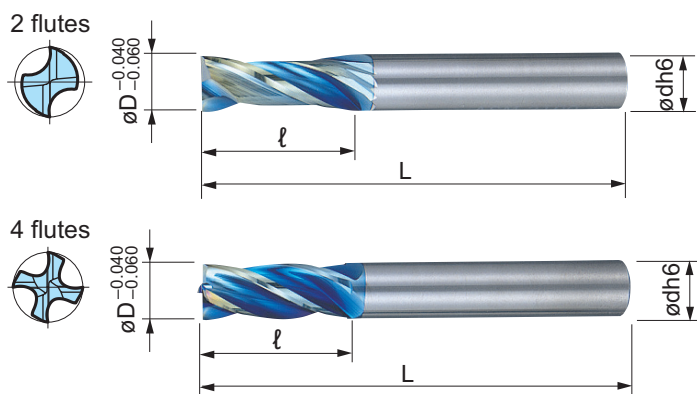


SOLID CARBIDE ENDMILLS

DLC (Diamond Like Carbon) AURORA COAT Series for Non-ferrous Materials



Helix angle: 30°
Corner: Sharp edge
Dia. Range: ø2~16mm

Features & Benefits

- Very smooth AURORA COAT provides low adhesion and good surface finish in non-ferrous alloys.
- With lower cutting forces and rigidity, this series is suitable for low rigidity machines.
- Available in two and four flutes in both square and ballnose type endmills (see page 437 for SNB Series Ballnose.)

Endmill Series

Two Flutes - METRIC					
Catalog No.	Stock	Cutter Dia.d ø	Shank Dia.Dø	Flute Length l	Overall Length L
ASM2020DL	★	2.0mm	4.0mm	6.0mm	40.0mm
ASM2030DL	★	3.0mm	6.0mm	10.0mm	45.0mm
ASM2040DL	★	4.0mm	6.0mm	12.0mm	45.0mm
ASM2050DL	★	5.0mm	6.0mm	15.0mm	50.0mm
ASM2060DL	★	6.0mm	6.0mm	15.0mm	50.0mm
ASM2080DL	★	8.0mm	8.0mm	18.0mm	60.0mm
ASM2100DL	★	10.0mm	10.0mm	22.0mm	71.0mm
ASM2120DL	★	12.0mm	12.0mm	25.0mm	75.0mm
ASM2160DL	★	16.0mm	16.0mm	32.0mm	90.0mm

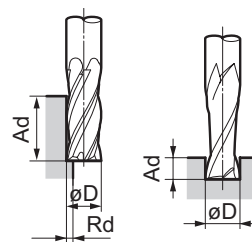
Grade: DL1000

Four Flutes - METRIC					
Catalog No.	Stock	Cutter Dia.d ø	Shank Dia.Dø	Flute Length l	Overall Length L
ASM4020DL	★	2.0mm	4.0mm	6.0mm	40.0mm
ASM4030DL	★	3.0mm	6.0mm	10.0mm	45.0mm
ASM4040DL	★	4.0mm	6.0mm	12.0mm	45.0mm
ASM4050DL	★	5.0mm	6.0mm	15.0mm	50.0mm
ASM4060DL	★	6.0mm	6.0mm	15.0mm	50.0mm
ASM4080DL	★	8.0mm	8.0mm	18.0mm	60.0mm
ASM4100DL	★	10.0mm	10.0mm	22.0mm	71.0mm
ASM4120DL	★	12.0mm	12.0mm	25.0mm	75.0mm
ASM4160DL	★	16.0mm	16.0mm	32.0mm	90.0mm

Grade: DL1000

Recommended Running Conditions

Radius mm	Aluminum Alloy								
	Wet (Emulsion)				Dry				
	Side Milling (4 flute)		Groove Milling (2 flute)		Side Milling (4 flute)		Groove Milling (2 flute)		
	RPM	Feed Rate mm/min. (ipt)	RPM	Feed Rate mm/min. (ipt)	RPM	Feed Rate mm/min. (ipt)	RPM	Feed Rate mm/min. (ipt)	
2	40,000	1,400 (55)	28,000	280 (11)	40,000	980 (38)	28,000	200 (7)	
3	32,000	2,000 (80)	22,000	400 (16)	32,000	1,400 (55)	22,000	280 (11)	
4	26,000	2,600 (102)	18,000	520 (20)	26,000	1,800 (70)	18,000	360 (14)	
5	20,000	2,600 (102)	14,000	520 (20)	20,000	1,800 (70)	14,000	360 (14)	
6	17,000	2,700 (106)	12,000	540 (21)	17,000	1,900 (74)	12,000	370 (14)	
8	13,000	2,700 (106)	9,000	540 (21)	13,000	1,900 (74)	9,000	370 (14)	
10	11,000	2,800 (110)	7,200	560 (22)	11,000	2,000 (80)	7,200	390 (15)	
12	8,500	2,800 (110)	6,000	560 (22)	8,500	2,000 (80)	6,000	390 (15)	
16	6,400	2,800 (110)	4,500	560 (22)	6,400	2,000 (80)	4,500	390 (15)	
D.O.C.	Ad	1.5D		1.0D		1.5D		0.5D	
	Pf	0.2D		1.0D		0.2D		1.0D	

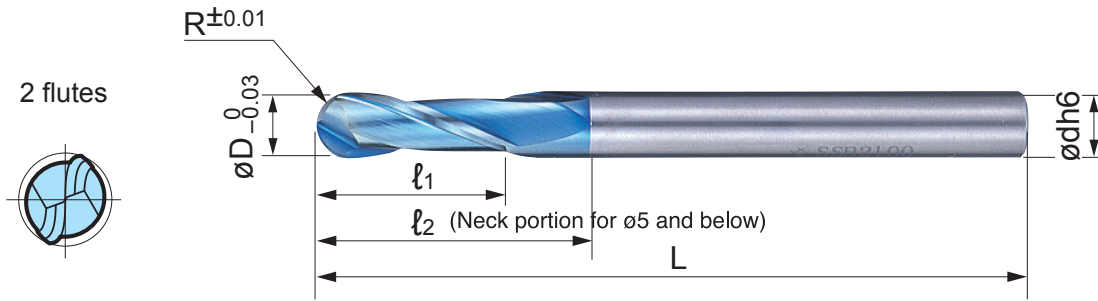


- For groove milling of stainless steel, use 60% recommended RPM and 40% feed rate.
- If cutting noise and vibration occur, please reduce the cutting speed accordingly.



DLC (Diamond Like Carbon) **AURORA COAT Series**
for Non-ferrous Materials

SOLID CARBIDE
ENDMILLS



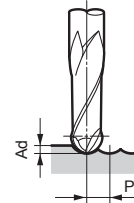
Helix angle :30°

Two Flutes - METRIC							
Sumitomo Catalog No.	Stock	R	øD	ℓ ₁	ℓ ₂	L	ød
SNB2020DL	★	1.0mm	2.0mm	3.0mm	5.0mm	60mm	6.0mm
SNB2030DL	★	1.5mm	3.0mm	4.5mm	8.0mm	80mm	6.0mm
SNB2040DL	★	2.0mm	4.0mm	6.0mm	12.0mm	80mm	6.0mm
SNB2050DL	★	2.5mm	5.0mm	7.5mm	14.0mm	90mm	6.0mm
SNB2060DL	★	3.0mm	6.0mm	9.0mm	-	100mm	6.0mm
SNB2080DL	★	4.0mm	8.0mm	12.0mm	-	100mm	8.0mm
SNB2100DL	★	5.0mm	10.0mm	15.0mm	-	120mm	10.0mm
SNB2120DL	★	6.0mm	12.0mm	18.0mm	-	120mm	12.0mm
SNB2160DL	★	8.0mm	16.0mm	24.0mm	-	160mm	16.0mm

Grade: DL1200

Recommended Running Conditions

Radius. mm	Aluminum Alloy			
	Wet (Emulsion)		Dry	
	RPM	Feed Rate mm/min. (ipt)	RPM	Feed Rate mm/min. (ipt)
2	48,000	1,500 (60)	48,000	1,000 (40)
3	38,000	2,100 (83)	38,000	1,500 (60)
4	31,000	2,800 (110)	31,000	2,000 (80)
5	24,000	2,800 (110)	24,000	2,000 (80)
6	20,000	2,800 (110)	20,000	2,000 (80)
8	15,000	2,800 (110)	15,000	2,000 (80)
10	13,000	3,000 (118)	13,000	2,100 (83)
12	10,000	3,000 (118)	10,000	2,100 (83)
16	7,700	3,000 (118)	7,700	2,100 (83)
D.O.C.	Ad	0.1D		0.1D
	Pf	0.2D		0.2D



- If cutting noise and vibration occur, please reduce the cutting speed accordingly.
- If the machine cannot reach recommended speed, use the maximum speed that can be achieved.

